

Date: Wednesday, 3/12/2008 1:41:50 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	HANDLE WELDMENT		
Job Number	37853		Part Number	D2530		
Estimate Number	10333		Drawing Number	D2530 REV B		
P.O. Number	:		Project Number	N/A		
This Issue	3/12/2008	S.O. No. :	Drawing Revision	B		
Prsht Rev.	NC		Material	:		
First Issue	1 /	Type : SMALL /MED FAB	Due Date	4/4/2008	Qty:	20
Previous Run	37546		Um:	Each		
Written By	:					
Checked & Approved By	:					
Comment	Est Rev:E	Removed Purchasing	05-11-07	JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304TR0750W049	304 RD Tube .750 x .049W
Comment: Qty.: 3.0602 f(s)/Unit Total : 61.2045 f(s) Material: 304/316 SS Seamless Tubing 0.75" OD x 0.049" wall(M304TR0.750W.049) Batch: M107688		
2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Cut to length as per Dwg D2533		
	2-Deburr	
3.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP		
4.0	D2534	Lock Plate
Comment: Qty.: 2.0000 Each(s)/Unit Total : 40.0000 Each(s) Pick: QTY Part # Description Batch 337919 → 28x 2 D2534 Lock Plate B37563 → 10x 08-05-13 80		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Weld as per Dwg D2530 and QSI 004 using Welding Jig DT8301		
	2-Deburr	
Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Weld as per Dwg D2530 and QSI 004 using Welding Jig DT8301		
	2-Deburr	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HANDLE WELDMENT

Job Number: 37853

Part Number: D2530

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-05-14 (20)

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/05/15 (4)

30 min
15/05/2008

8.0 POWDER COATING

POWDER COATING



M 105642

S.252 13.48

#1 72.1.6 F
#2 337853 F

#3 D2530 F
#4

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

M. 08/0

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



08

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-05-15 (20)

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 204

JS 08/05/16 (20)

11.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/16 (20)

Job Completion



MF 08-05-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



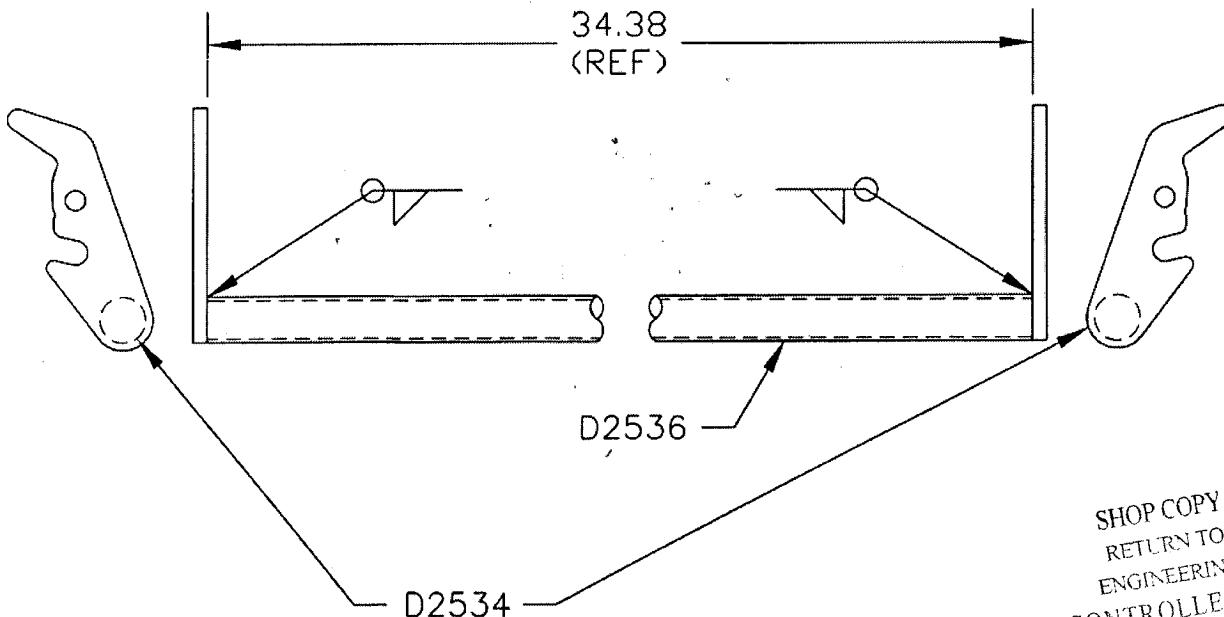
DESIGN B. WILLIAMS	DRAWN BY PH	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2530
DATE 04.12.14		REV. B SHEET 1 OF 1
		TITLE HANDLE WELDMENT
A	96.06.18	SCALE NEW ISSUE
B	04.12.14	UPDATE NOTES AND DIMENSIONS

RELEASED

04.12.16 *[initials]*

PART LIST -- D2530

QTY	PART NUMBER	DESCRIPTION
X	D2530	HANDLE WELDMENT
1	D2536	HANDLE
2	D2534	LOCK PLATE



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
NO. *37853*
WORK ORDER

D2530 HANDLE WELDMENT

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

